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D4634-145
Job Sheet 167078-J



Part No: D4634-145

Job Qty: 1 ea

Part Name: Aft, Center Ceiling Replacement Panel Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/24/17

Job Tracking No:

Due Date: 11/10/17

Created By: Mario Poulin

Type: SOLD

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	1 Ea		11/9/17	0.00	0.00	Start up container	18/01/17 <i>DL</i>
100	HandThermo	1 pcs		11/9/17	0.00	1.65	HandFinish4	18/01/17 <i>DL</i>
110	Small Fab	1 pcs		11/10/17	0.00	1.47	Small Fab	18/01/17 <i>DL</i>
120	QC	1 pcs		11/10/17	0.00	0.00	QC5	<i>38</i>
130	Packaging	1 pcs		11/10/17	0.00	0.00	Packaging3	<i>18-1-31</i>
140	QC21-SA	1 Ea		11/10/17	0.00	0.00	QC21	<i>21</i>

Part Op 100 - Pick Kit

Descriptions: 110 - Assemble as per Dwg D4634-145 Bond foam core to inside of panel 3M Scotch Weld 1300

Batch: _____ 1- Scuff bonding surface to eliminate in-perfections and increase bonding and clean with wash& wipe 2- Locate and glue down Channel Assy, angles, brackets, and mounting pads using 3M Plastic welder II.(see note 8) Batch # 135649 Expiry Date 18/01/17 3- Apply labels as per Dwg. and seal with 3M 3950 edge sealer(see note 9) Batch: 135735

120 - QC5- Inspect part completeness to step on W/O

130 - Identify as per dwg & Stock Location: _____

140 - QC21- Final Inspection - Work Order Release

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D4634-5 <i>5031487</i>	1	3	0	0
	<i>ST 107</i> D4636-5 <i>5004455</i>	1	43	0	0
	<i>MF001</i> D4647-1 <i>5003354</i>	1	4	0	0
	" D4664-5 <i>5011418</i>	6	39	0	0
	" D4712-1 <i>5008996</i>	1	4	0	0
	" D4732-17 <i>5020431</i>	1	0	0	0
	" D4732-23 <i>5008998</i>	1	1	0	0
	" D4732-27 <i>5020428</i>	1	1	0	0
	D5021-5 <i>5012876</i>	1	1	0	0
	<i>ST570</i> MPNY-750S-9-C <i>FM1304231</i>	9	570	0	0
	<i>ST 312</i> MS20426AD3-4 <i>FM134284</i>	4	5,055	0	0
	<i>ST 312</i> MS20426AD4-6 <i>FM138621</i>	2	2,797	0	0
	<i>ST 311</i> MS21059L08 <i>5006416</i>	2	62	0	0

Part Specifications

Specifications could not be found.

F164290.

5033146

Plex 10/24/17 10:18 AM dart.poulin.mario

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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Date : _____	Step #: _____	QTY Effective : _____	MRB (QSI042) Approval S033146 Aft, Center Ceiling Replacement Panel Assembly PART NO: D4634 – 145 Original Serial #: S033146 Revision: Operation: HandThermo Change No: Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K64 1K7 CANADA TEL.: 1 613 632 – 5200 Email: sales@dartaero.com www.dartaerospace.com
			Completed By _____
			Lead hand / Supervisor Approval Verification _____
			QC / QA Coordinator Approval _____

Root Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Clump/Noty approved ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabelled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
Mfg Date: 01/17/18 Job No: 167078 – J					
OTHER : _____					